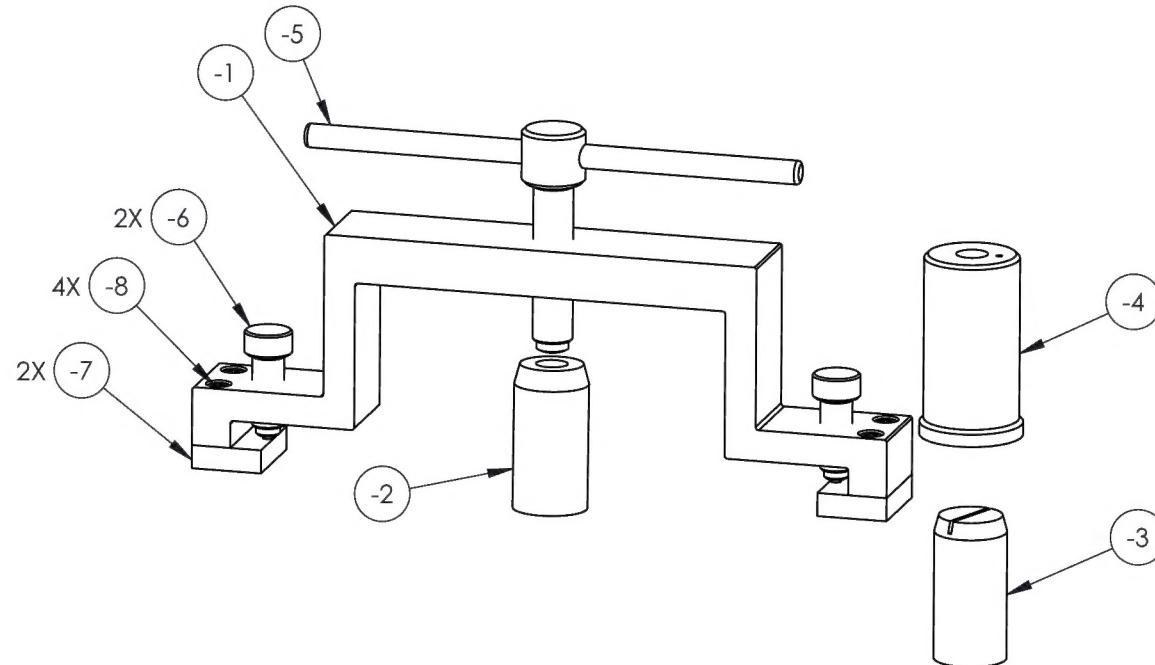


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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1	14-0231	REDRAWN FROM TATTERED HARD TO READ DRAWING. -1 USE OPTIONAL ON PIECE CONSTRUCTION.			12/30/2014	RJC	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PRESS	1018		2
			-2	1	DRIFT	4140/4142		3
			-3	1	GUIDE	4140/4142		4
			-4	1	SLEEVE	4140-4142		5
X			-5	1	SCREW ASSEMBLY			6
1			-5A		THREADED BOLT	4130		7
1			-5B		HANDLE	1018/1020		8
			-6	2	SCREW	1018/1020		9
			-7	2	CLAMP PRESS	1018/1020		10
		B/O	-8	4	SOCKET HEAD CAP SCREW	STEEL	1/4-20 UNC X 1 (MCMASTER-CARR #92562A271)	1
ASSY -5	ASSY -1							

DART AEROSPACE

TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.

DWG NO. RB6872543 **REV** 1

MAT'L	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .02 ANGLES ±1°	
HEAT TREAT FINISH	
SPEC	
USED ON MODEL	
ENGINE MODELS 250 SERIES	
SCALE	1:3
DATE	12/29/2014
SHEET 1 OF 10	

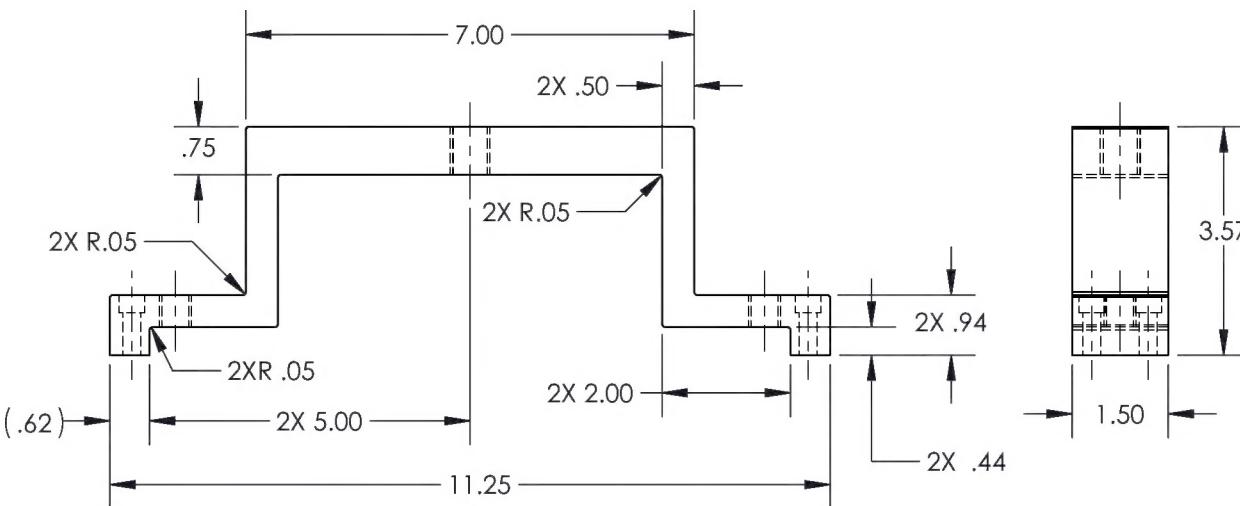
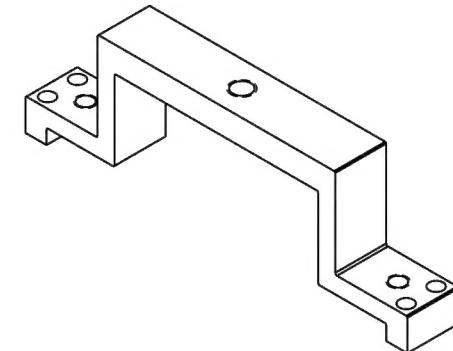
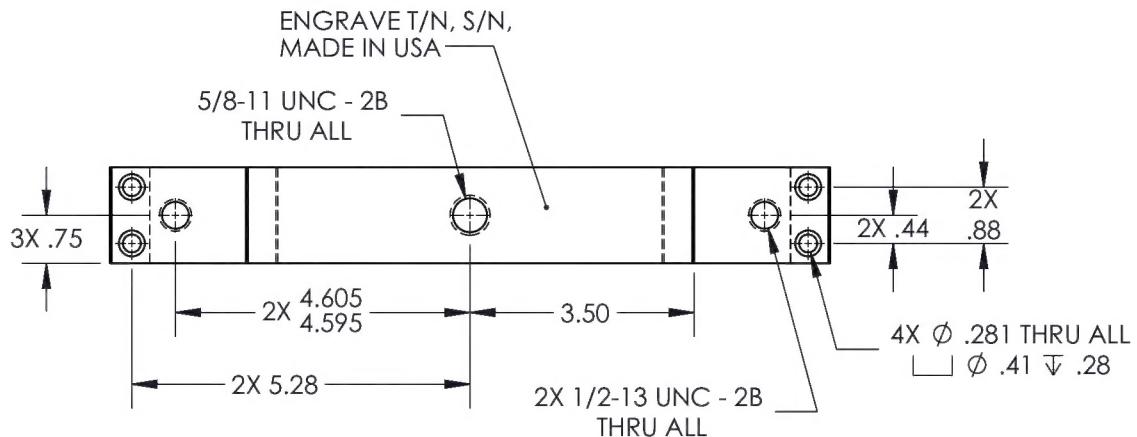
J Gilbert

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

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REV	ECR	REVISIONS		
		DESCRIPTION	DATE	INITIAL
				APPROVED



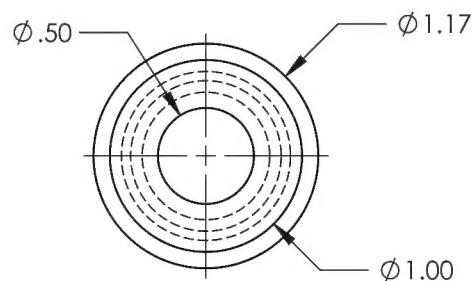
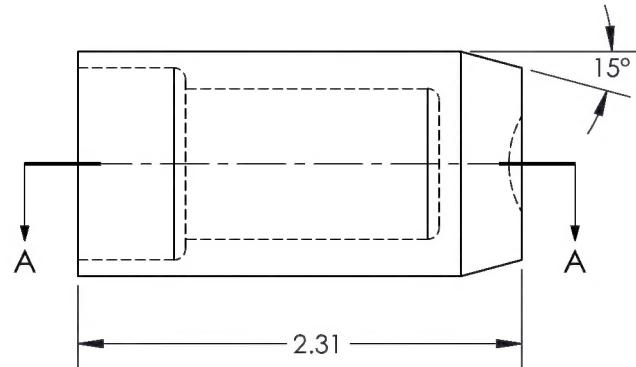
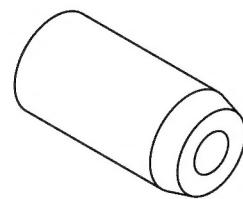
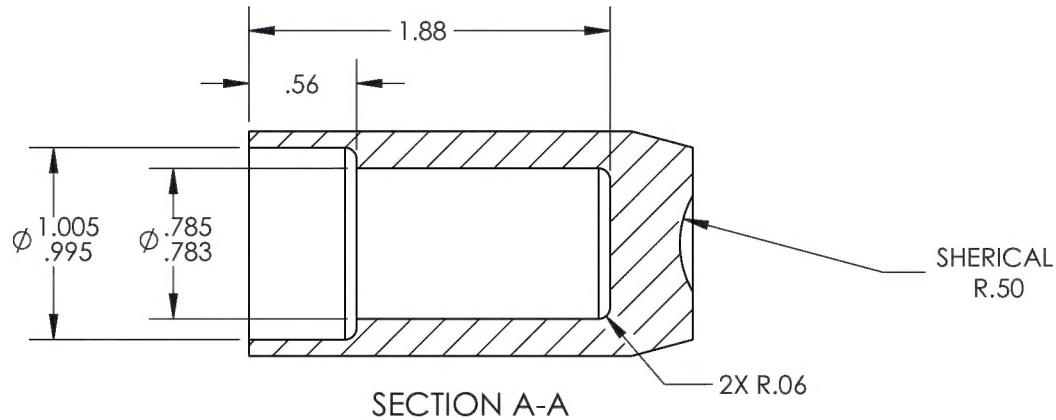
(-1)

PRESS

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR GAS PRODUCER FRONT BRG.	
DWG NO.	RB6872543-1
MAT'L	1018
DRAWN BY:	CLOUGH
APPROVED	<i>J Gilbert</i>
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .010	FRACTIONS ± 1/8
.XX ± .02	ANGLES ± 1°
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	ENGINE MODELS 250 SERIES
SCALE	1:3
DATE	1/9/2015
SHEET 2 OF 10	

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
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(-2)

DRIFT

DART
AEROSPACE

TITLE PRESS-INSTALLATION, POWER TURBINE
REAR & GAS PRODUCER FRONT BRG.

DWG NO. RB6872543-2 **REV** 1

MAT'L 4140/4142 **DRAWN BY:** CLOUGH

APPROVED J. Gilbert

HEAT TREAT RC 36-40

FINISH CAD PLATE YELLOW

SPEC QQ-P-416F, TYPE II, CLASS II

USED ON MODEL ENGINE MODELS 250 SERIES

PLATING

SCALE 1:1 **DATE** 12/29/2014 **SHEET** 3 OF 10

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .02 ANGLES ± 1°

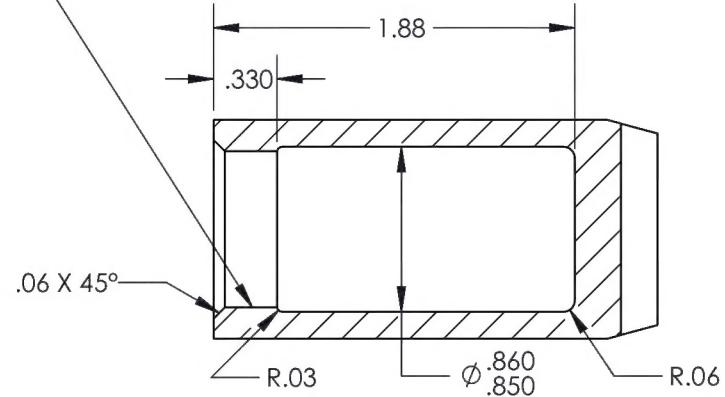
1. BREAK ALL SHARP EDGES .015 x 45°
OR .015R

2. DIMENSIONAL LIMITS APPLY AFTER
PLATING

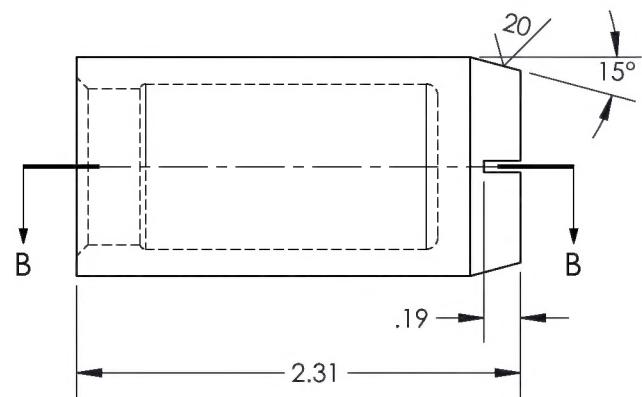
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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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.8133 - .8176 MINOR DIA. MOD. THRU
.844-32 UNS-3B MOD. THRU
P.D. = .8235-.8271

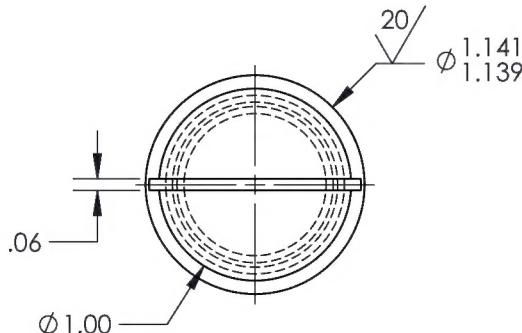
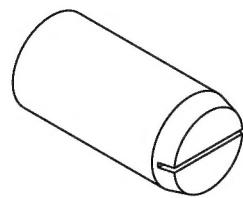


SECTION B-B



(3)

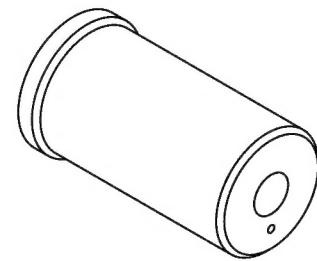
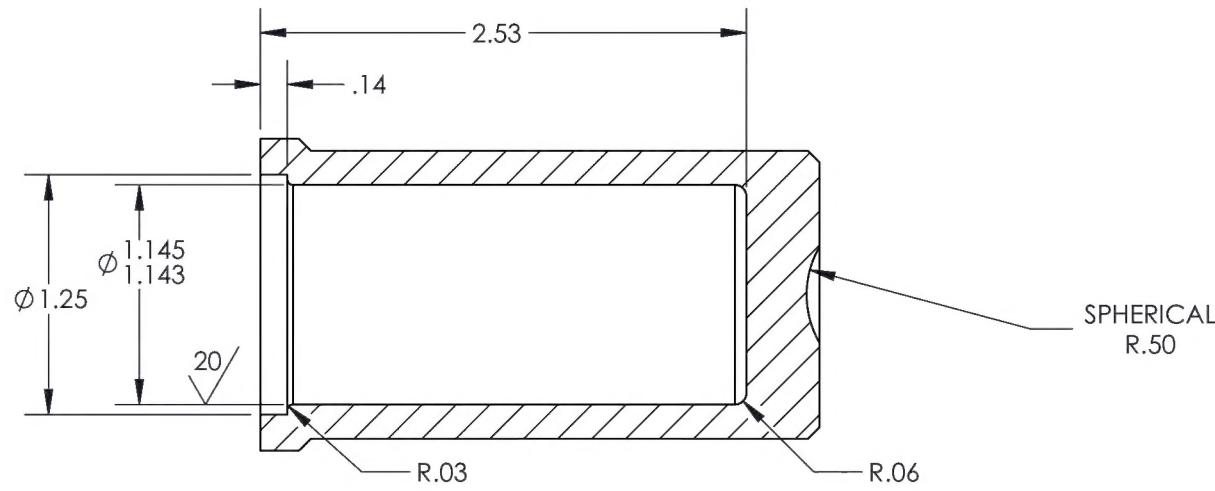
GUIDE



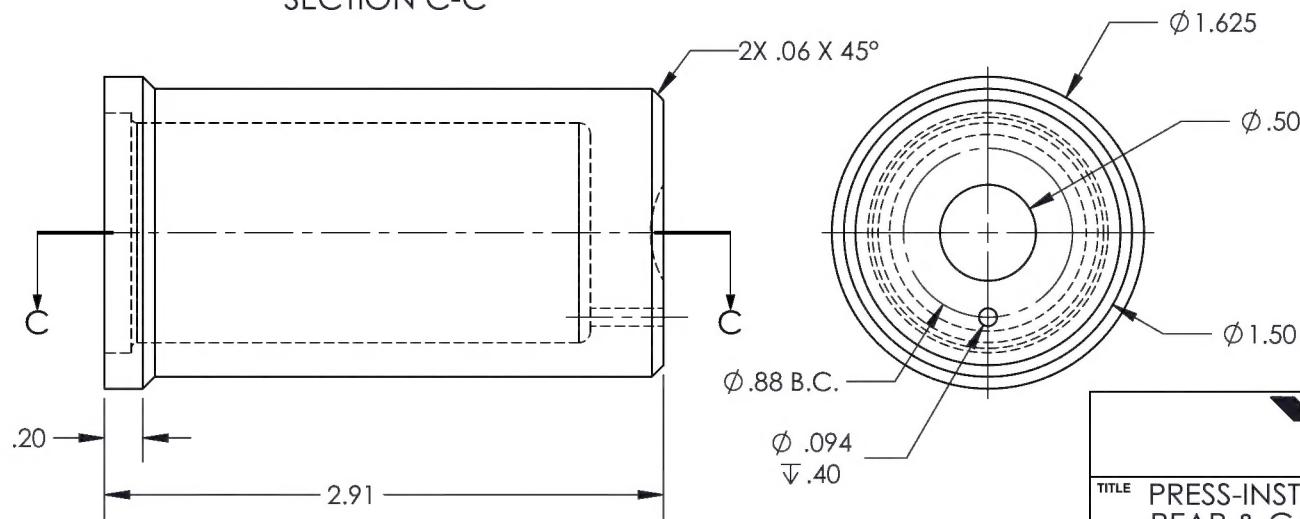
DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO.	RB6872543-3
MAT'L	4140/4142
DRAWN BY: CLOUGH	
APPROVED <i>J. Gilbert</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .02 ANGLES ± 1°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	
ENGINE MODELS 250 SERIES	
SCALE	1:1
DATE	12/29/2014
SHEET 4 OF 10	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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SECTION C-C



(4)

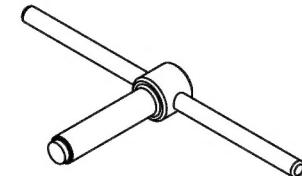
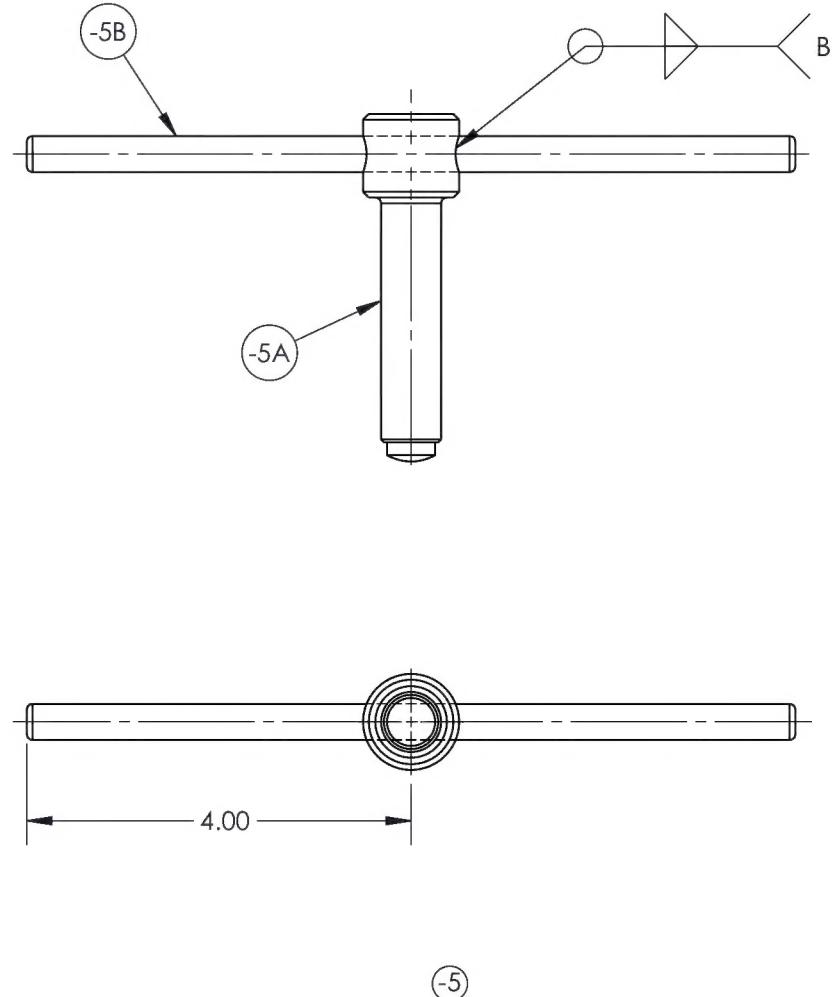
SLEEVE

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO.	RB6872543-4
MAT'L	4140-4142
DRAWN BY:	CLOUGH
APPROVED	<i>J. Gilbert</i>
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .010	FRACTIONS ± 1/8
.XX ± .02	ANGLES ± 1°
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	
ENGINE MODELS 250 SERIES	
SCALE	1:1
DATE	12/29/2014
SHEET 5 OF 10	

REV
1

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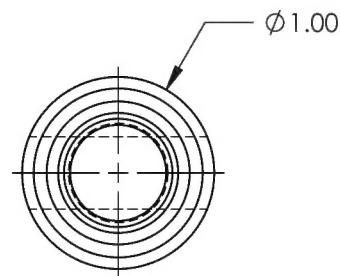
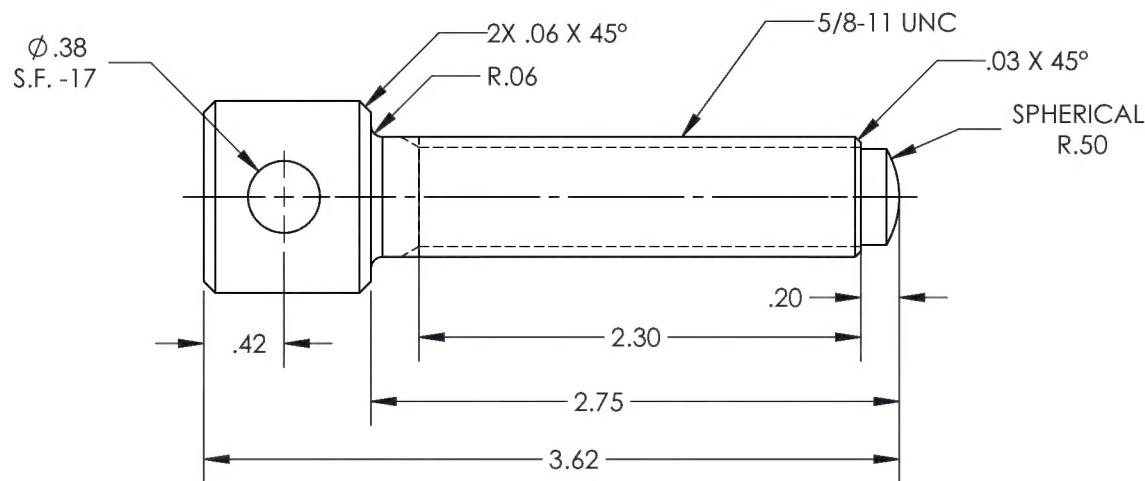
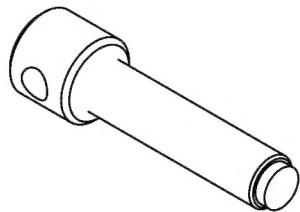
REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO.	RB6872543-5
MAT'L	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .02 ANGLES ± 1°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
HEAT TREAT	USED ON MODEL
FINISH CAD PLATE YELLOW	ENGINE MODELS 250 SERIES
SPEC QQ-P-416F, TYPE II, CLASS II	
SCALE 1:1	DATE 12/29/2014
SHEET 6 OF 10	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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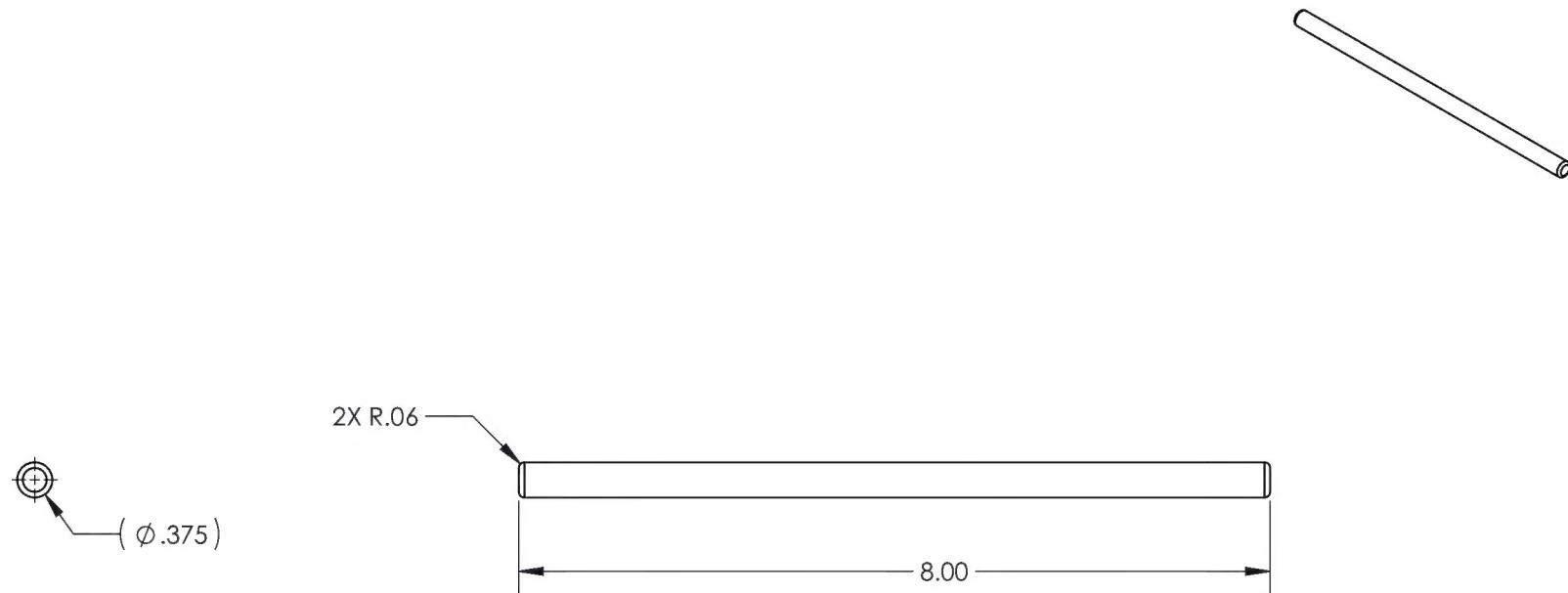


-5A
THREADED BOLT

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO.	RB6872543-5A
MAT'L	4130
DRAWN BY:	CLOUGH
UNLESS OTHERWISE SPECIFIED	APPROVED
DIMENSIONS ARE IN INCHES	J. Gilbert
.XXX ± .010	FRACTIONS ± 1/8
.XX ± .02	ANGLES ± 1°
HEAT TREAT RC 32-36	
FINISH SEE -5	
SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	
ENGINE MODELS 250 SERIES	
SCALE	1:2
DATE	12/29/2014
SHEET 7 OF 10	

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REV		ECR		DESCRIPTION			DATE	INITIAL	APPROVED
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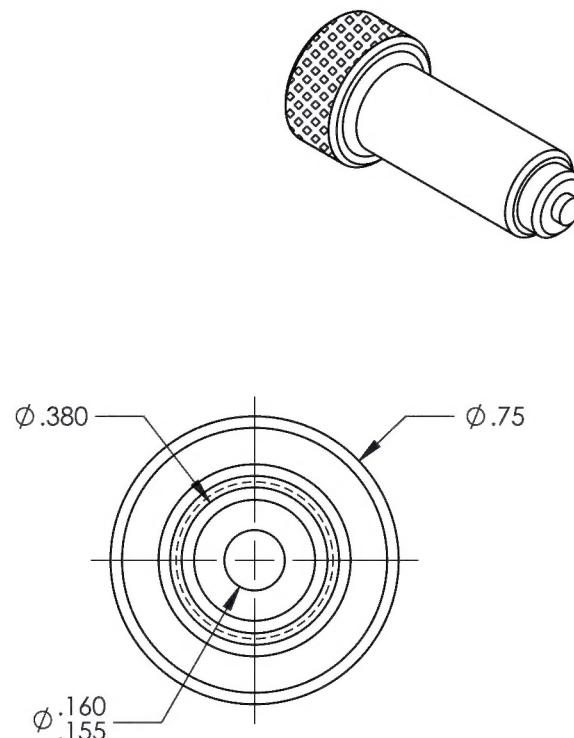
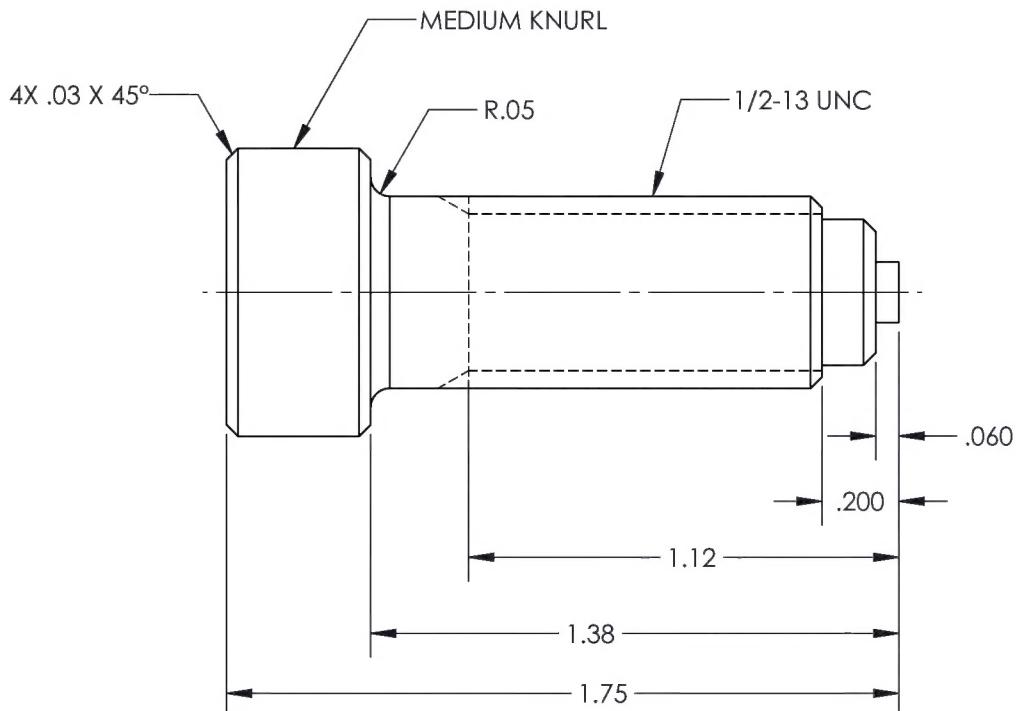


DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO.	RB6872543-5B
MAT'L	1018/1020
DRAWN BY: CLOUGH	
APPROVED <i>J Gilbert</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .02 ANGLES ± 1°	
HEAT TREAT	
FINISH SEE -5	
SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	
ENGINE MODELS 250 SERIES	
SCALE	1:2
DATE	12/29/2014
SHEET 8 OF 10	

-5B

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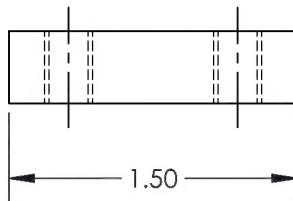
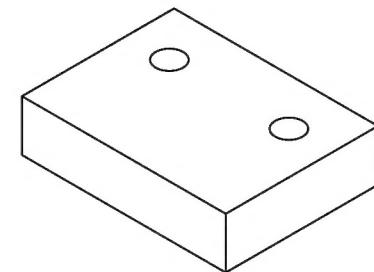
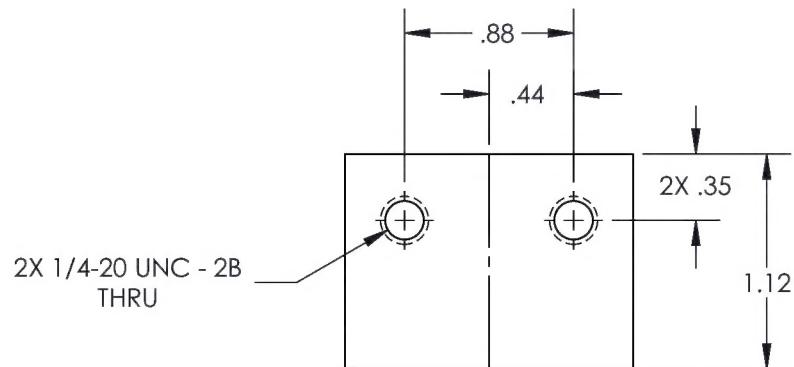
REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO.	RB6872543-6
MAT'L	1018/1020
DRAWN BY: CLOUGH	
APPROVED <i>J Gilbert</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .02 ANGLES ± 1°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SPEC QQ-P-416F, TYPE II, CLASS II	
USED ON MODEL	
ENGINE MODELS 250 SERIES	
SCALE	1:1
DATE	12/29/2014
SHEET 9 OF 10	

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(7)

CLAMP PRESS

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO.	RB6872543-7
MAT'L	1018/1020
DRAWN BY: CLOUGH	
APPROVED <i>J Gilbert</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .02 ANGLES ± 1°	
HEAT TREAT FINISH CAD PLATE YELLOW	
SPEC QQ-P-416F, TYPE II, CLASS II	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL ENGINE MODELS 250 SERIES	
SCALE	1:1
DATE	12/29/2014
SHEET 10 OF 10	

REV
1